



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

646.4002
Job Sheet 178088



Part No: 646.4002

Job Qty: 1 ea

Part Name: AS350 Wiper Deflector



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 5/26/18

Job Tracking No:

Due Date: 6/14/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV C1 IPP REV:A 12.12.23 NEW ISSUE DD VERF:JLM IPP REV:B 16.01.07 DWG REV.C DD
VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	1 Ea	6/14/18	6/14/18	0.00	0.00	Start Up Stores/Pkg-1		JUN 01 2018
110	Packaging	1 pcs	6/14/18	6/14/18	0.00	0.00	Packaging1-1		JUN 01 2018
120	QC	1 pcs	6/14/18	6/14/18	0.00	0.00	QC4		
130	Packaging	1 pcs	6/14/18	6/14/18	0.00	0.00	Packaging3-1		
135	DC	1 pcs	6/14/18	6/14/18	0.00	0.00	DC		
140	QC21-FG	1 Ea	6/14/18	6/14/18	0.00	0.00	QC21		1806-13

Part Op 130 - Identify and pack for shipping as per PPP 646.4002 Location : FG102
Descriptions: 135 - Photocopy bluefile & type labels per PPP 646.4002

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
600.1012	Sealant PR1425B2 (#654 sem)	1 pcs (1 ea)	90-Start up Operation	
646.3410	LH Wiper Deflector	1 Ea (1 ea)	90-Start up Operation	
646.3411	RH Wiper Deflector	1 Ea (1 ea)	90-Start up Operation	
646.3814	Wiper Bracket	2 Ea (2 ea)	90-Start up Operation	
MS21042L3	Nut	6 Ea (6 ea)	90-Start up Operation	
MS24694-S53	Screw	2 Ea (2 ea)	90-Start up Operation	
MS27039-1-18	Screw	2 Ea (2 ea)	90-Start up Operation	
MS27039-1-19	Screw	2 Ea (2 ea)	90-Start up Operation	
NAS1149F0332P	Washer	16 Ea (16 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	600.1012	1	13	0
	646.3410	1	8	0
	646.3411	1	10	0
	646.3814	2	20	0
	MS21042L3	6	1,322	0
	MS24694-S53	2	229	0
	MS27039-1-18	2	1,321	0
	MS27039-1-19	2	550	0
	NAS1149F0332P	16	3,278	0

3592

DQ:

Date: _____

WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed:

Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :		Step #:		QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation				Disposition			
				Completed By _____			
				Lead hand / Supervisor Approval Verification _____			
				QC / QA Coordinator Approval _____			
Root Cause				FAULT CATEGORIES			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐				
Design ☐	Operator ☐	Bending ☐	Set-up ☐				
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐				
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐				
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐				
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐				
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐				
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐				
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐				
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐				
Past Expiry Date ☐	Manufacturing Process ☐						
Misidentified ☐	Past Due ☐	OTHER : _____					

Part: 646.4002
 Job No: 178088
 Serial No/Batch: S077085
 Revision:
 Inspector:
 Exp Date: 06/01/2018
 Instructions:

Date: 06/01/18



Dart Aerospace Ltd.
 1270 Aberdeen Street
 Newmarket, ON K6A 1K7
 CANADA
 TEL: 1 813 632-5200
 Email: sales@dartaero.com
 www.dartaerospace.com

Positioned Wrong
 Outside Dimensions
 Over/Under tolerance
 Part Incorrect
 Part Lost/Missing
 Part Moved
 Drawing
 Finish
 Misread
 Turning Sequence

Part Specifications

Specifications could not be found.

Plex 5/28/18 7:21 AM Dart.lajeunesse.marie

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table border="0"> <tr> <td>Skid-tube ☐</td> <td>Cross tube ☐</td> <td>Water Jet ☐</td> <td>Engineering ☐</td> </tr> <tr> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐																																															
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Container View (Active) - Master Unit Containers

11/18

Master Unit No	Container No	Part No	Part Name	From Container	Current Location	Quantity
003592	S077040	600.1012	Sealant PR1425B2 (#654 sem)	s074966	ST123	1
003592	S077038	646.3410	LH Wiper Deflector	S032566	CCK010	1
003592	S077037	646.3411	RH Wiper Deflector	S032533	CCK010	1
003592	S077035	MS21042L3	Nut	S075328	ST303	6
003592	S077033	MS24694-S53	Screw	F113359	ST284	2
003592	S077032	MS27039-1-18	Screw	F124326	OVER006	2
003592	S077031	MS27039-1-19	Screw	S065263	ST280	2
003592	S077030	NAS1149F0332P	Washer	S068663	ST262	16

Note: Ad hoc query view of Part.dbo.Container where Container.Active = 1.

Plex 6/1/18 9:22 AM dart.quirion.sonia

446.3814 S07055x2

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NOTES:

1 AFTER INSTALLATION, APPLY F/N 54 A/R TO FILL GAPS AND FILLET EDGES.

2 INSTALL F/N 14 WITH F/N 52 & 53.

3 3M VHB ADHESIVE TAPE .025" THICK X .50" WIDE
VENDOR: MCMASTER-CARR P/N 75935A651.

4 3M TAPE PRIMER 94, APPLY TO BOTH SURFACES A/R BEFORE TAPE.
VENDOR: R.S. HUGHES P/N 021200-24216.

5 REUSE FASTENERS FROM F/N 1.

6 USE WASHERS A/R AS SHIMS TO OBTAIN BEST FITMENT.

7 AT CUSTOMERS OPTION, INSTALL F/N 65 BY MATCH DRILLING ON TO F/N 1.

8 INSTALL SHIM IF OEM PROVISIONS ARE INSTALLED ON AIRCRAFT. REMOVE SHIM LAYERS TO ACHIEVE CORRECT SIZE. MATCH DRILL HOLES. USE F/N 78 SCREW IN PLACE OF F/N 17 SCREW.

9 NEWER INSTALLATIONS ON AIRCRAFT WITH UPDATED CANOPY MAY REQUIRE DIFFERENT LENGTH SCREWS. USE F/N 62 TO REPLACE F/N 44 & F/N 26 IN PLACE OF F/N 41 WHEN NECESSARY.

UNINCORPORATED ECN(S)

05304

5	5	5	78	601.3875	SCREW	APICAL INDUSTRIES DBA DART AEROSPACE
1	1	1	77	646.9410	SHIM	UNINCORPORATED ECN(S)
	4	4	76	601.2764	WASHER	UNINCORPORATED ECN(S)
	2	2	75	601.2973	LOCKNUT	UNINCORPORATED ECN(S)
	2	2	74	601.2988	SCREW	UNINCORPORATED ECN(S)
	2	2	73	601.2943	LOCKNUT	UNINCORPORATED ECN(S)
	2	2	72	601.3128	NUT	UNINCORPORATED ECN(S)
	2	2	71	601.3209	LOCKNUT	UNINCORPORATED ECN(S)
	4	4	70	601.2638	WASHER	UNINCORPORATED ECN(S)
	2	2	69	601.2649	BOLT	UNINCORPORATED ECN(S)
	2	2	68	601.3119	CLEVIS	UNINCORPORATED ECN(S)
	2	2	67	601.3121	EYE BOLT	UNINCORPORATED ECN(S)
	2	2	66	650.9201	EYE BRACKET ASSY	UNINCORPORATED ECN(S)
	REF	REF	65	647.5701	GPS MOUNT KIT	UNINCORPORATED ECN(S)
		2	64	601.3151	WASHER	UNINCORPORATED ECN(S)
		2	63	601.2911	SCREW	UNINCORPORATED ECN(S)
	24	24	62	601.2637	SCREW	UNINCORPORATED ECN(S)
2	2	2	61	601.2763	BOLT	UNINCORPORATED ECN(S)
	1	1	60	646.3913	SHIM	UNINCORPORATED ECN(S)
	4	4	59	646.3912	SHIM	UNINCORPORATED ECN(S)
	1	1	58	646.3911	SHIM	UNINCORPORATED ECN(S)
	4	4	57	646.3910	SHIM	UNINCORPORATED ECN(S)
	5	5	56	600.1013	PRIMER	UNINCORPORATED ECN(S)
	8 FT	8 FT	55	600.0129	VHB TAPE	UNINCORPORATED ECN(S)
	1	1	54	600.1012	SEALANT	UNINCORPORATED ECN(S)
	1	1	53	600.0991	MAGNETIC COAT 6398 PART B	UNINCORPORATED ECN(S)
	1	1	52	600.0990	MAGNETIC COAT 6398 PART A	UNINCORPORATED ECN(S)
6	10	10	51	601.2826	BOLT	UNINCORPORATED ECN(S)
		2	50	646.3814	WIPER BRACKET	UNINCORPORATED ECN(S)
		2	49	601.2910	SCREW	UNINCORPORATED ECN(S)
	2	2	48	601.1365	SCREW	UNINCORPORATED ECN(S)
	2	2	47	646.3719	DOUBLER	UNINCORPORATED ECN(S)
		2	46	646.3718	CUSTOM WASHER	UNINCORPORATED ECN(S)
	1	1	45	646.3717	DOUBLER	UNINCORPORATED ECN(S)
	22	22	44	601.1948	SCREW	UNINCORPORATED ECN(S)
	2	2	43	601.1952	SCREW	UNINCORPORATED ECN(S)
	4	4	42	601.1956	SCREW	UNINCORPORATED ECN(S)
4000	4003	4004	4005	4006	4007	4008
REF	REF	REF	REF	REF	REF	REF
5	5	5	78	601.3875	SCREW	APICAL INDUSTRIES DBA DART AEROSPACE
1	1	1	77	646.9410	SHIM	UNINCORPORATED ECN(S)
	4	4	76	601.2764	WASHER	UNINCORPORATED ECN(S)
	2	2	75	601.2973	LOCKNUT	UNINCORPORATED ECN(S)
	2	2	74	601.2988	SCREW	UNINCORPORATED ECN(S)
	2	2	73	601.2943	LOCKNUT	UNINCORPORATED ECN(S)
	2	2	72	601.3128	NUT	UNINCORPORATED ECN(S)
	2	2	71	601.3209	LOCKNUT	UNINCORPORATED ECN(S)
	4	4	70	601.2638	WASHER	UNINCORPORATED ECN(S)
	2	2	69	601.2649	BOLT	UNINCORPORATED ECN(S)
	2	2	68	601.3119	CLEVIS	UNINCORPORATED ECN(S)
	2	2	67	601.3121	EYE BOLT	UNINCORPORATED ECN(S)
	2	2	66	650.9201	EYE BRACKET ASSY	UNINCORPORATED ECN(S)
	REF	REF	65	647.5701	GPS MOUNT KIT	UNINCORPORATED ECN(S)
		2	64	601.3151	WASHER	UNINCORPORATED ECN(S)
		2	63	601.2911	SCREW	UNINCORPORATED ECN(S)
	24	24	62	601.2637	SCREW	UNINCORPORATED ECN(S)
2	2	2	61	601.2763	BOLT	UNINCORPORATED ECN(S)
	1	1	60	646.3913	SHIM	UNINCORPORATED ECN(S)
	4	4	59	646.3912	SHIM	UNINCORPORATED ECN(S)
	1	1	58	646.3911	SHIM	UNINCORPORATED ECN(S)
	4	4	57	646.3910	SHIM	UNINCORPORATED ECN(S)
	5	5	56	600.1013	PRIMER	UNINCORPORATED ECN(S)
	8 FT	8 FT	55	600.0129	VHB TAPE	UNINCORPORATED ECN(S)
	1	1	54	600.1012	SEALANT	UNINCORPORATED ECN(S)
	1	1	53	600.0991	MAGNETIC COAT 6398 PART B	UNINCORPORATED ECN(S)
	1	1	52	600.0990	MAGNETIC COAT 6398 PART A	UNINCORPORATED ECN(S)
6	10	10	51	601.2826	BOLT	UNINCORPORATED ECN(S)
		2	50	646.3814	WIPER BRACKET	UNINCORPORATED ECN(S)
		2	49	601.2910	SCREW	UNINCORPORATED ECN(S)
	2	2	48	601.1365	SCREW	UNINCORPORATED ECN(S)
	2	2	47	646.3719	DOUBLER	UNINCORPORATED ECN(S)
		2	46	646.3718	CUSTOM WASHER	UNINCORPORATED ECN(S)
	1	1	45	646.3717	DOUBLER	UNINCORPORATED ECN(S)
	22	22	44	601.1948	SCREW	UNINCORPORATED ECN(S)
	2	2	43	601.1952	SCREW	UNINCORPORATED ECN(S)
	4	4	42	601.1956	SCREW	UNINCORPORATED ECN(S)
4000	4003	4004	4005	4006	4007	4008
REF	REF	REF	REF	REF	REF	REF
5	5	5	78	601.3875	SCREW	APICAL INDUSTRIES DBA DART AEROSPACE
1	1	1	77	646.9410	SHIM	UNINCORPORATED ECN(S)
	4	4	76	601.2764	WASHER	UNINCORPORATED ECN(S)
	2	2	75	601.2973	LOCKNUT	UNINCORPORATED ECN(S)
	2	2	74	601.2988	SCREW	UNINCORPORATED ECN(S)
	2	2	73	601.2943	LOCKNUT	UNINCORPORATED ECN(S)
	2	2	72	601.3128	NUT	UNINCORPORATED ECN(S)
	2	2	71	601.3209	LOCKNUT	UNINCORPORATED ECN(S)
	4	4	70	601.2638	WASHER	UNINCORPORATED ECN(S)
	2	2	69	601.2649	BOLT	UNINCORPORATED ECN(S)
	2	2	68	601.3119	CLEVIS	UNINCORPORATED ECN(S)
	2	2	67	601.3121	EYE BOLT	UNINCORPORATED ECN(S)
	2	2	66	650.9201	EYE BRACKET ASSY	UNINCORPORATED ECN(S)
	REF	REF	65	647.5701	GPS MOUNT KIT	UNINCORPORATED ECN(S)
		2	64	601.3151	WASHER	UNINCORPORATED ECN(S)
		2	63	601.2911	SCREW	UNINCORPORATED ECN(S)
	24	24	62	601.2637	SCREW	UNINCORPORATED ECN(S)
2	2	2	61	601.2763	BOLT	UNINCORPORATED ECN(S)
	1	1	60	646.3913	SHIM	UNINCORPORATED ECN(S)
	4	4	59	646.3912	SHIM	UNINCORPORATED ECN(S)
	1	1	58	646.3911	SHIM	UNINCORPORATED ECN(S)
	4	4	57	646.3910	SHIM	UNINCORPORATED ECN(S)
	5	5	56	600.1013	PRIMER	UNINCORPORATED ECN(S)
	8 FT	8 FT	55	600.0129	VHB TAPE	UNINCORPORATED ECN(S)
	1	1	54	600.1012	SEALANT	UNINCORPORATED ECN(S)
	1	1	53	600.0991	MAGNETIC COAT 6398 PART B	UNINCORPORATED ECN(S)
	1	1	52	600.0990	MAGNETIC COAT 6398 PART A	UNINCORPORATED ECN(S)
6	10	10	51	601.2826	BOLT	UNINCORPORATED ECN(S)
		2	50	646.3814	WIPER BRACKET	UNINCORPORATED ECN(S)
		2	49	601.2910	SCREW	UNINCORPORATED ECN(S)
	2	2	48	601.1365	SCREW	UNINCORPORATED ECN(S)
	2	2	47	646.3719	DOUBLER	UNINCORPORATED ECN(S)
		2	46	646.3718	CUSTOM WASHER	UNINCORPORATED ECN(S)
	1	1	45	646.3717	DOUBLER	UNINCORPORATED ECN(S)
	22	22	44	601.1948	SCREW	UNINCORPORATED ECN(S)
	2	2	43	601.1952	SCREW	UNINCORPORATED ECN(S)
	4	4	42	601.1956	SCREW	UNINCORPORATED ECN(S)
4000	4003	4004	4005	4006	4007	4008
REF	REF	REF	REF	REF	REF	REF

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396, 397, 398, 399, 400, 401, 402, 403, 404, 405, 406, 407, 408, 409, 410, 411, 412, 413, 414, 415, 416, 417, 418, 419, 420, 421, 422, 423, 424, 425, 426, 427, 428, 429, 430, 431, 432, 433, 434, 435, 436, 437, 438, 439, 440, 441, 442, 443, 444, 445, 446, 447, 448, 449, 450, 451, 452, 453, 454, 455, 456, 457, 458, 459, 460, 461, 462, 463, 464, 465, 466, 467, 468, 469, 470, 471, 472, 473, 474, 475, 476, 477, 478, 479, 480, 481, 482, 483, 484, 485, 486, 487, 488, 489, 490, 491, 492, 493, 494, 495, 496, 497, 498, 499, 500, 501, 502, 503, 504, 505, 506, 507, 508, 509, 510, 511, 512, 513, 514, 515, 516, 517, 518, 519, 520, 521, 522, 523, 524, 525, 526, 527, 528, 529, 530, 531, 532, 533, 534, 535, 536, 537, 538, 539, 540, 541, 542, 543, 544, 545, 546, 547, 548, 549, 550, 551, 552, 553, 554, 555, 556, 557, 558, 559, 560, 561, 562, 563, 564, 565, 566, 567, 568, 569, 570, 571, 572, 573, 574, 575, 576, 577, 578, 579, 580, 581, 582, 583, 584, 585, 586, 587, 588, 589, 590, 591, 592, 593, 594, 595, 596, 597, 598, 599, 600, 601, 602, 603, 604, 605, 606, 607, 608, 609, 610, 611, 612, 613, 614, 615, 616, 617, 618, 619, 620, 621, 622, 623, 624, 625, 626, 627, 628, 629, 630, 631, 632, 633, 634, 635, 636, 637, 638, 639, 640, 641, 642, 643, 644, 645, 646, 647, 648, 649, 650, 651, 652, 653, 654, 655, 656, 657, 658, 659, 660, 661, 662, 663, 664, 665, 666, 667, 668, 669, 670, 671, 672, 673, 674, 675, 676, 677, 678, 679, 680, 681, 682, 683, 684, 685, 686, 687, 688, 689, 690, 691, 692, 693, 694, 695, 696, 697, 698, 699, 700, 701, 702, 703, 704, 705, 706, 707, 708, 709, 710, 711, 712, 713, 714, 715, 716, 717, 718, 719, 720, 721, 722, 723, 724, 725, 726, 727, 728, 729, 730, 731, 732, 733, 734, 735, 736, 737, 738, 739, 740, 741, 742, 743, 744, 745, 746, 747, 748, 749, 750, 751, 752, 753, 754, 755, 756, 757, 758, 759, 760, 761, 762, 763, 764, 765, 766, 767, 768, 769, 770, 771, 772, 773, 774, 775, 776, 777, 778, 779, 780, 781, 782, 783, 784, 785, 786, 787, 788, 789, 790, 791, 792, 793, 794, 795, 796, 797, 798, 799, 800, 801, 802, 803, 804, 805, 806, 807, 808, 809, 810, 811, 812, 813, 814, 815, 816, 817, 818, 819, 820, 821, 822, 823, 824, 825, 826, 827, 828, 829, 830, 831, 832, 833, 834, 835, 836, 837, 838, 839, 840, 841, 842, 843, 844, 845, 846, 847, 848, 849, 850, 851, 852, 853, 854, 855, 856, 857, 858, 859, 860, 861, 862, 863, 864, 865, 866, 867, 868, 869, 870, 871, 872, 873, 874, 875, 876, 877, 878, 879, 880, 881, 882, 883, 884, 885, 886, 887, 888, 889, 890, 891, 892, 893, 894, 895, 896, 897, 898, 899, 900, 901, 902, 903, 904, 905, 906, 907, 908, 909, 910, 911, 912, 913, 914, 915, 916, 917, 918, 919, 920, 921, 922, 923, 924, 925, 926, 927, 928, 929, 930, 931, 932, 933, 934, 935, 936, 937, 938, 939, 940, 941, 942, 943, 944, 945, 946, 947, 948, 949, 950, 951, 952, 953, 954, 955, 956, 957, 958, 959, 960, 961, 962, 963, 964, 965, 966, 967, 968, 969, 970, 971, 972, 973, 974, 975, 976, 977, 978, 979, 980, 981, 982, 983, 984, 985, 986, 987, 988, 989, 990, 991, 992, 993, 994, 995, 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